

5830
 (x8)
 (Stuck x2)
 7-16



Dart Aerospace Ltd.
 1270 Aberdeen St
 Hawkesbury, ON
 K6A 1K7
 Canada

Tel (613) 632-5200

RB T102103
Job Sheet 180635



Part No: RB T102103

Job Qty: 6 ea *7*

Part Name: Dehydrator Tail Rotor



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/11/18

Job Tracking No:

Due Date: 7/16/18

Created By: Logan David

Type: SOLD

Description:

Note: IPP Rev A 17.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/16/18	0.00	0.00	Start Up Small Fab-4		MLL
110	Small Fab	6 pcs		7/16/18	0.00	2.00	Small Fab-3		MLL
120	QC	6 pcs		7/16/18	0.00	0.00	QC5		MLL
130	Packaging	6 pcs		7/16/18	0.00	0.00	Packaging3-1		MLL
140	QC21-FG	6 Ea		7/16/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per DWG. Sheet 1 ****MS27215-2 Plug Dehydrator must be Blue**** ****Immediately vacuum seal RB
 Descriptions: T102103 after assy***

DAS
 53
 9-89

JUL 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS27215-2	18 mm Dehydrator Plug Alternate p/n AN814-20D	6 Ea (1 ea)	90-Start up Operation	5012153
MS29561-210	Packing / Oring	6 Ea (1 ea)	90-Start up Operation	5001637
RB T102103-3	Adapter	6 Ea (1 ea)	90-Start up Operation	5033370
RB T102103-5	Retainer	6 Ea (1 ea)	90-Start up Operation	5032334
RB T102103-7	Pin	6 Ea (1 ea)	90-Start up Operation	5090978

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MS27215-2	6	18	0
	MS29561-210	6	115	0
	RB T102103-3	6	13	0
	RB T102103-5	6	13	0
	RB T102103-7	6	0	0

Part Specifications

Specifications could not be found.

Plex 7/11/18 1:20 PM dart.logan.david



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Container No: S091367



Part: RB T102103

Job No: 180635

Serial No/Batch: S091367

Revision: C

Inspector:

Exp Date:

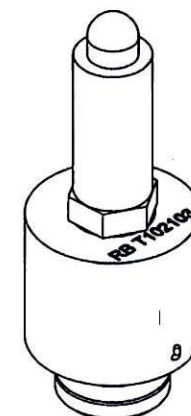
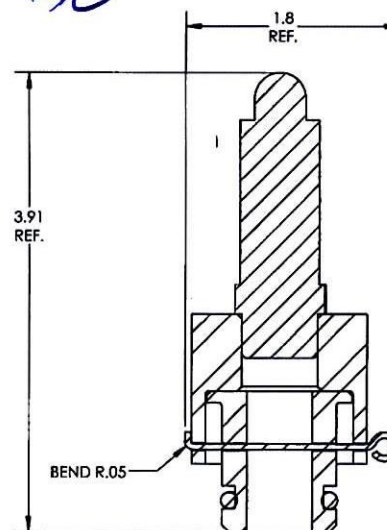
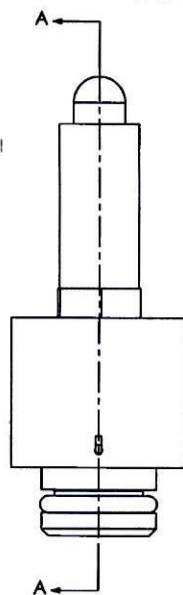
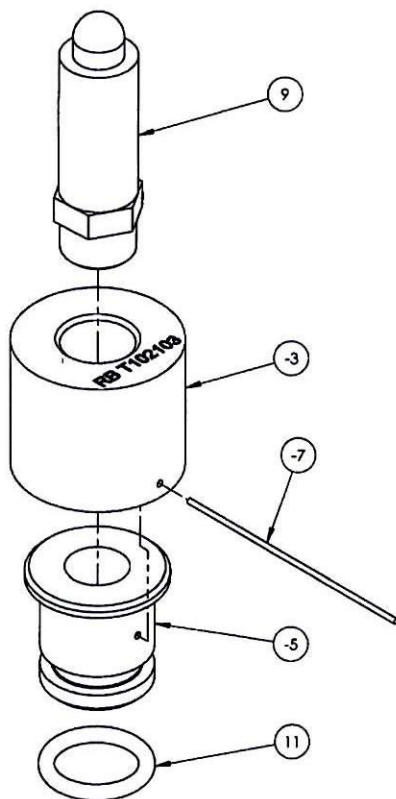
Instructions:

Date: 07/12/18

ITEM #	QTY	PART #	TITLE	PG
-3	1	RB T102103-3	ADAPTER	2
-5	1	RB T102103-5	RETAINER	3
-7	1	RB T102103-7	PIN .050" OD. x 2-1/2" LG.	4
9	1	MS27215-2	PLUG DEHYDRATOR	-
11	1	MS29561-210	O-RING 1.012" OD x 0.135" THK	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-	REDRAWN FROM TATTERED ORIGINAL DRAWING	-	11/1/2012	RJC	SE
A	-3 CH'D NOTE WAS FINE DIAMOND OR STRAIGHT KNURL THIS SURFACE IS MEDIUM DIAMOND OR STRAIGHT KNURL THIS SURFACE	-	3/11/2014	DPD	GE
1	-3 ADDED BOTH SIDES TO CHAMFER	15-0156	7/1/2015	SM	JAG
C	ADD SHEET 4 FOR -7, TEMPLATE UPDATED, REMOVE GD&T COCENTRICITY TOLERANCE ON -5, REMOVE LIMIT TOLERANCE FOR 0.008"X0.061" HOLE ON -5, ADD 2 PL. ON RADIUS .015"X.005" ON -3 & -5	17-709	17.10.16	VM	WM

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190635
20180711



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

RB T102103 DEHYDRATOR TAIL ROTOR

DART AEROSPACE Newbury, Ontario, Canada	
TITLE DEHYDRATOR TAIL ROTOR	
DRW NO. RB T102103	REV. C
DESIGN BY: VM 10/16/2017	XXX 2.500 FRACTIONS 2 1/8
DRAWN BY: VM 10/28/2017	XX 1/2 1/4 ANGLES 2.5°
CHECKED: SAC 10/27/2017	1 SURFACES = 114
MPG APPR: DP 10/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: VM 10/31/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 4	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				